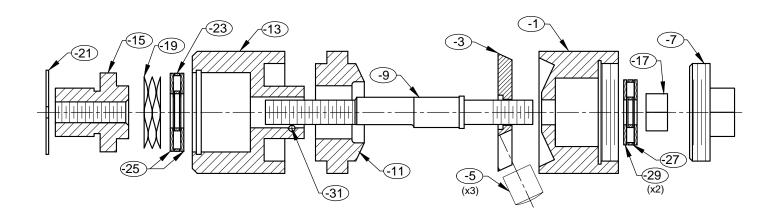
	REVISIONS									
RE	DESCRIPTION	DATE	INITIAL	APPROVED						
1	CH'D -1, -3, -9 -11 & -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. ADDED 2ND FLAT ON -13.	7/26/12	RJC	SE						



NOTES

- 1. -5 ROLLERS AND -3 RETAINER MUST TURN SMOOTHLY ON -1 BASE WHEN ASSEMBLED.
- 2. FLAT END OF -5 ROLLERS MUST FACE THE CENTER OF TOOL WHEN ASSEMBLED.

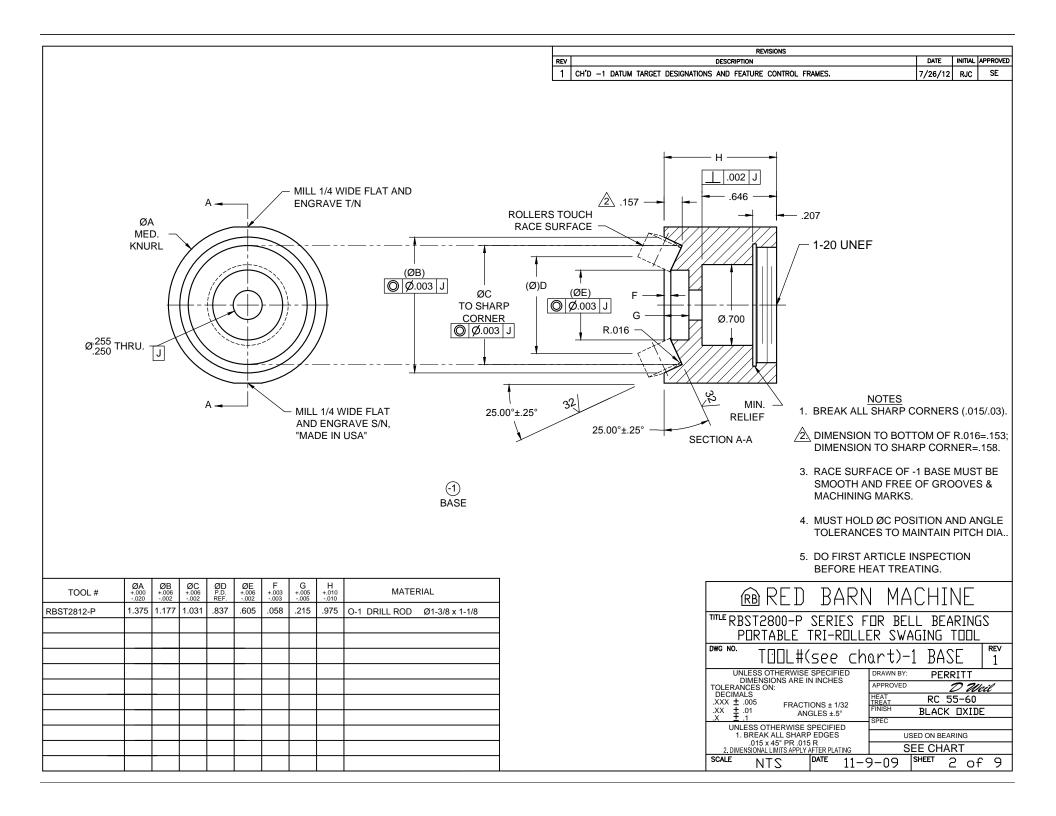
									_
ASSY QTY	ASSY QTY	B/O	PART#	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.	
			-1	1	BASE		SEE CHART	2	
			-3	1	RETAINER		SEE CHART	3	
			-5	3	ROLLER		SEE CHART	4	
			-7	1	CAP		SEE CHART	5	
			-9	1	STUD		SEE CHART	6]
			-11	1	DUAL SEAT		SEE CHART	7]
			-13	1	RECEIVER		SEE CHART	8]_
			-15	1	TENSIONER		SEE CHART	9]"
		B/O	-17	1	DISTORTED THREAD LOCK NUT	STEEL	1/4-20 UNC x 7/32 Ht. MCMASTER-CARR #95065A150	1	
		B/O	-19	1	CREST TO CREST FLAT WIRE WAVE SPRING	STEEL	.750 OD., .550 ID., WIRE THICK013, THREE TURNS SMALLEY RING CO. #CS075-H1	1	ַ"[
		B/O	-21	1	INTERNAL SNAP RING	STEEL	Ø7/8 BORE MCMASTER-CARR #99142A410	1	┢
		B/O	-23	1	THRUST BEARING (SPRING SIDE)	STEEL	Ø3/8 ID. x 13/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-613)	1	Т
		B/O	-25	2	BEARING WASHER	STEEL	Ø3/8 ID. x 13/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-613)	1] .
		B/O	-27	1	THRUST BEARING	STEEL	Ø1/4 ID. x 11/16 OD. x 5/64 WIDTH APPLIED (TIMKEN #NTA-411)	1	Ŀ
		B/O	-29	2	BEARING WASHER	STEEL	Ø1/4 ID. x 11/16 OD. x 1/32 WIDTH APPLIED (TIMKEN #TRA-411)	1]
		B/O	-31	1	ROLL PIN	STEEL	Ø3/32 x 3/8	N/S	L
	ASSY #								[5
					I.		I .		

BEARINGS & TOOLS COVERED								
BEARING #	TOOL#							
206-010-470-101	RBST2812-P							

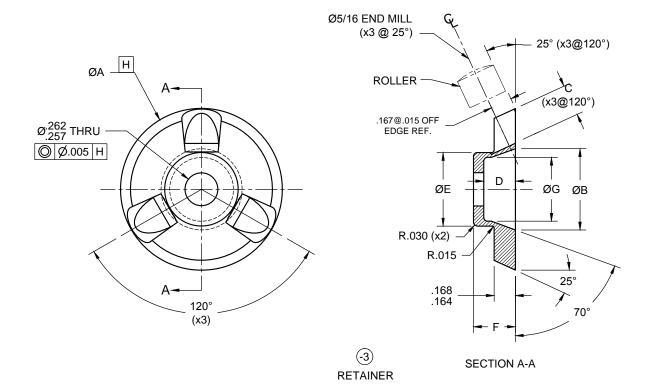
RED BARN MACHINE

TILE RBST2800-P SERIES FOR BELL BEARINGS
PORTABLE TRI-ROLLER SWAGING TOOLS

	LUKTUREF IKI-K	CULLE	K 2MA	טווט		
	DWG NO. SEE CHART AB	BOVE	· FOR	TOOL	No.	REV 1
	UNLESS OTHERWISE SPECIF		DRAWN BY:	PER	RITT	
	DIMENSIONS ARE IN INCHE TOLERANCES ON:	:5	APPROVED		D We	ril
	DECIMALS .XXX ± .005 FRACTIONS ± 1	1/32	HEAT TREAT			
	.XX ± .01 ANGLES ± .1		FINISH			
_	UNLESS OTHERWISE SPECIFII	ED	SPEC			
	1. BREAK ALL SHARP EDGES	3	US	SED ON BEA	ARING	
S	.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLA	ATING	S	EE CHA	RT	
	SCALE NTS DATE	11-9	9-09	SHEET	1 of	9



	REVISIONS												
REV	DESCRIPTION	DATE	INITIAL	APPROVED									
1	CH'D -3 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC	SE									



NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

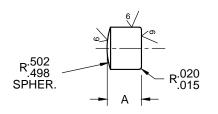
TOOL#	ØA +.002 002	ØB +.005 005	+.003 003	D +.010 010	ØE +.005 005	F +.005 005	ØG +.005 005	P.D. REF.	MATERIAL
RBST2812	1.265	.635	.247	.250	.575	.328	.500	.837	BRONZE RND. BAR Ø1-3/8 x 1/2

RED BAR	N MACHINE							
RBST2800P SERIES F								
DWG NO. TOOL#(see char	DWG NO. TOOL#(see chart)-3 RETAINER 1							
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS	DRAWN BY: PERRITT APPROVED D Weil HEAT							
.XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ±.5°	TREAT FINISH SPEC							
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES	USED ON BEARING							
.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SEE CHART							
SCALE NTS DATE 11-	9-09 SHEET 3 of 9							

REVISIONS

REV DESCRIPTION DATE INITIAL APPROVED





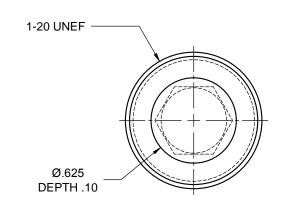
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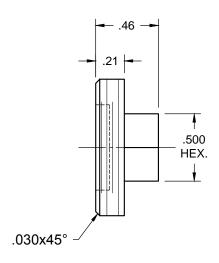
ROLLER

TOOL#	+.001 001		MATERIAL						
RBST2812	.251	.310 MINUS	GAUGE PIN	MSC #89031009					

® RED	BARN	I MA	CHI	N	E			
RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL								
DWG NO. T□□□ L #(⊆	DWG NO. TOOL#(see chart)-5 ROLLER 1							
UNLESS OTHERWISE		DRAWN BY:	PER	RRIT	ГТ			
TOLERANCES ON:	N INCHES	APPROVED		0	Wed	il		
DECIMALS .XXX ± .005	IONS ± 1/32	HEAT TREAT	RC	55-	-60			
.XX ± .01 ΔN	GLES ±.5°	FINISH						
.X ± .1 /** UNLESS OTHERWISE S	SPECIFIED	SPEC						
1. BREAK ALL SHARE	EDGES	USED ON BEARING						
.015 x 45° PR .015 2. DIMENSIONAL LIMITS APPLY		S	EE CHA	۱RT	•			
scale NTS	DATE 11-9	9-09	SHEET	4	of	9		

REVISIONS DATE INITIAL APPROVED REV DESCRIPTION





<u>-7</u> CAP

TOOL#	MA [·]	TERIAL
RBST2812	1018 RND. BAR	Ø1 x 5/8

® RED	BARN	MACHINE

TITLE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON:
DECIMALS DRAWN BY: APPROVED HEAT TREAT FINISH

.XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ±.5°

DWG NO.

UNLESS OTHERWISE SPECIFIED

1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

BLACK DXIDE USED ON BEARING SEE CHART

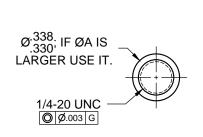
PERRITT

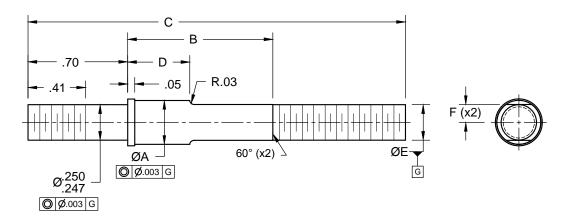
D Weil

REV

DATE 11-9-09 SHEET 5 of 9 NTS

	REVISIONS											
REV	DESCRIPTION	DATE	INITIAL	APPROVED								
1	CH'D -9 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC	SE								





-9 STUD

TOOL#	ØA +.000 002	B +.010 005	C +.005 010	D +.010 010	E	F +.000 003	MATERIAL
RBST2812	.310	1.647	3.000	.738	1/4-28 UNF	.124	4140 G&P RND. BAR Ø1/2 x 3-1/8

RED BARN MACHINE

PORTABLE TRI-ROLLER SWAGING TOOL

DWG NO. TOOL#(see chart)-9 STUD 1

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ON:
DECIMALS
.XXX ± .005
.XXX ± .005
.XXX ± .01
.X ± .01

± 1/32 HEAT TREAT FINISH BLACK DXIDE SPEC

DRAWN BY:

APPROVED

UNLESS OTHERWISE SPECIFIED

1. BREAK ALL SHARP EDGES

.015 x 45° PR .015 R

2. DIMENSIONAL LIMITS APPLY AFTER PLATING

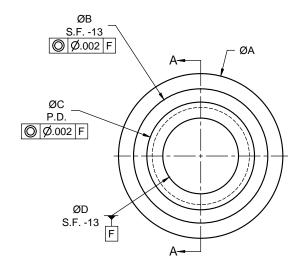
USED ON BEARING
SEE CHART
-09 SHEET 6 of 9

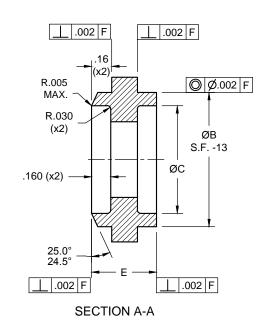
PERRITT

D Weil

LE NTS DATE 11-9-09 SHEET

REVISIONS									
REV	DESCRIPTION	DATE	INITIAL	APPROVED					
1	CH'D -11 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES.	7/26/12	RJC	SE					





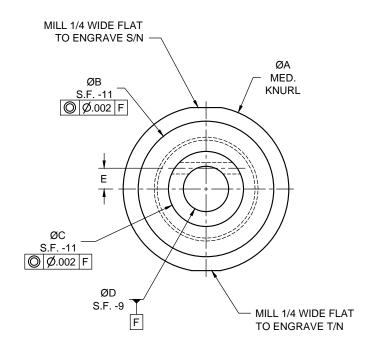
(-11)

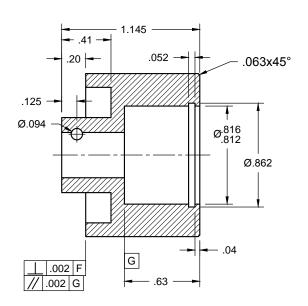
DUAL SEAT

TOOL#	ØA +.010 020	ØB +.000 003	ØC +.002 000	ØD +.005 003	E +.010 010	MATERIAL	
RBST3008P	1.375	1.122	.837	.632	.710	4140 Q&T RND. BAR Ø1-3/8 x 7/8	

® RED	BARN	1 MA	СН	ΙN	Ε	
RBST2800-P PORTABLE						S
DWG NO.TOOL#(see	chart))-11 Dl	JAL	SE	AT	REV 1
UNLESS OTHERWISE		DRAWN BY:	PE	RRI	ГТ	
TOLERANCES ON:	N INCHES	APPROVED		0	Wei	il
DECIMALS .XXX ± .005		HEAT TREAT				
VV I M	IONS ± 1/32 GLES ±.5°	FINISH	BLAC	КΠ	XIDE	
UNLESS OTHERWISE S	SPECIFIED	SPEC				
1. BREAK ALL SHARE	PEDGES	USED ON BEARING				
.015 x 45° PR .015 2. DIMENSIONAL LIMITS APPLY	SEE CHART					
scale NTS	DATE 11-9	9-09	SHEET	7	of	9

	REVISIONS										
[REV	DESCRIPTION	DATE	INITIAL	APPROVED						
ſ	1	CH'D -13 DATUM TARGET DESIGNATIONS AND FEATURE CONTROL FRAMES. ADDED 2ND FLAT.	7/26/12	RJC	SE						



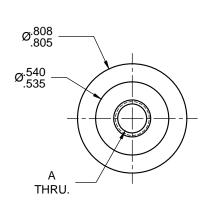


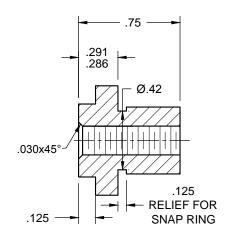
-13 RECIEVER

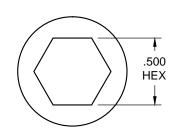
TOOL#	ØA +.010 010	ØB +.003 000	ØC +.003 003	ØD +.002 000	+.003 000		MATERIA	AL.
RBST2812	1.375	1.125	.622	.312	.175	4140 Q&T RND.BAR Ø1-3/8 x 1-1/4		

® RED BARN MACHINE TILE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL DWG NO. UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS DRAWN BY: PERRITT APPROVED D Weil HEAT TREAT FINISH .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 BLACK DXIDE ANGLES ±.5° UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES USED ON BEARING .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING SEE CHART SCALE DATE SHEET 11-9-09 8 of 9 NTS

REVISIONS DATE INITIAL APPROVED REV DESCRIPTION







(-15) **TENSIONER**

TOOL#	А	MATERIA	L
RBST2812	1/4-28 UNF	4140 Q&R RND. BAR	Ø7/8 x 7/8
			·

® RED BARN MACHINE TILE RBST2800-P SERIES FOR BELL BEARINGS PORTABLE TRI-ROLLER SWAGING TOOL

DWG NO. TOOL#(see chart) DRAWN BY:

APPROVED

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ±.5°

UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING HEAT TREAT FINISH BLACK DXIDE USED ON BEARING SEE CHART

SCALE DATE 11-9-09 NTS

SHEET 9 of 9

PERRITT

D Weil

	REVISIONS			
REV	DESCRIPTION	DATE	INITIAL	APPR
_		-	-	-

WOT APPROVED FOR PRODUCTION RED BARN MACHINE

Ā	SSY ASS	Y B/C	PART#	UNIT	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.	- πιε 	
Γ			-1	1	RND	6061	Ø8-1/4 x 3-7/8	2		
									- DWG NO	RE
									UNLESS OTHERWISE SPECIFIED DRAWN BY: PERRITT	
									DIMENSIONS ARE IN INCHES TOLERANCES ON: APPROVED	
									DECIMALS	
									XX ± .01 ANGLES ±.5° SPEC USED ON MODEL	
									1. BREAK ALL SHARP EDGES	
									.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
Γ	ASS	SY							SCALE NTS DATE 8-15-07 SHEET 1 C	f:

	REVISIONS		
REV	DESCRIPTION	DATE	APPROVED

NOT APPROVED FOR PRODUCTION

			PAR	Т#	QTY		DESCRIPTION			
			-1	ı	1					
		DRAWN BY: PERRITT			— \ Г		$D \wedge D M$	$\Lambda \Lambda \Lambda \cap$	LITN	$\overline{\Box}$
		CHECKED HEAT_		(<u>RB</u>	1 [2	くヒリ	RAKIN	MAL	$\Box\Box\Box$	1
		TREAT FINISH SPEC		TITLE						
[USED ON MODEL	UNLESS OTHERWISE SPECIFIE DIMENSIONS ARE IN INCHES	D							
	?	TOLERANCES ON: DECIMALS .XXX ± .005 EDACTIONS + 1						-		
ł		XX ± .005 FRACTIONS ± 1 .XX ± .01 ANGLES ±.6		DWG 1	NO.		PART	#		REV.
f		UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES)				1 1 11 \ 1	11		
		.015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	3	SCALE		NTS	DATE 1-28-0	06 ^{sheet} :	1 of	1